

Date: Tuesday, 11/29/2005 11:39:02 AM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ARM
Job Number	: 24983	Part Number	: D2012103
Estimate Number	: 10706	Drawing Number	: D2012.REV B2
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 11/29/2005 S.O. No. : N/A	Drawing Revision	: B2
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Due Date	: 12/15/2005
Previous Run	: N/A	Qty:	109
Written By	: SEE COMMENT BELOW	Um:	Each
Checked & Approved By	: SEE COMMENT BELOW		
Comment	: Est Rev: 02.04.03 Added Inspect level 3 NG		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TR0500W035	304 RD Tube .500 x .035W	
		Comment: Qty.: 3.5700 f(s)/Unit Total : 35.7000 f(s) Material: 304/316 Seamless SS tubing, 1/2" O.D. x .035" wall(M304TR0.500W.035) Identify as D2012-101 Batch: M19196	FF 05-12-05
2.0	BRAKE NC	NC BRAKE	
		Comment: NC BRAKE	
		1-Punch to length as per Dwg D2012-103 & template D2012-103T1	41.00" FF 05-12-05
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1	
		1-Deburr	PTO
		2-Bend D2012-103 as per template D2012-103T2 & Dwg D2012-103	FF 05-12-06
4.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	2 05-12-07
5.0	POWDER COATING	POWDER COATING	
		Comment: POWDER COATING Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3	FC 06 01 23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 06/01/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
05-12-06	3	27° Bend out of tolerance	<u>AB</u> <u>05/12/06</u>	Destroy arm (2012103) Or Scrap	FF 05-12-06	<u>AB</u> <u>05-12-06</u>	<u>AB</u> <u>05/12/06</u>	<u>AB</u> <u>05-12-06</u>

NOTE: Date & initial all entries

Date: Tuesday, 11/29/2005 11:39:03 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 24983

Part Number: D2012103

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

in

06 01 23

QFH
9

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 200

16 01/24

(9)

8.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

5uc- 06/01/25

⑨



06/01/25

⑦

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

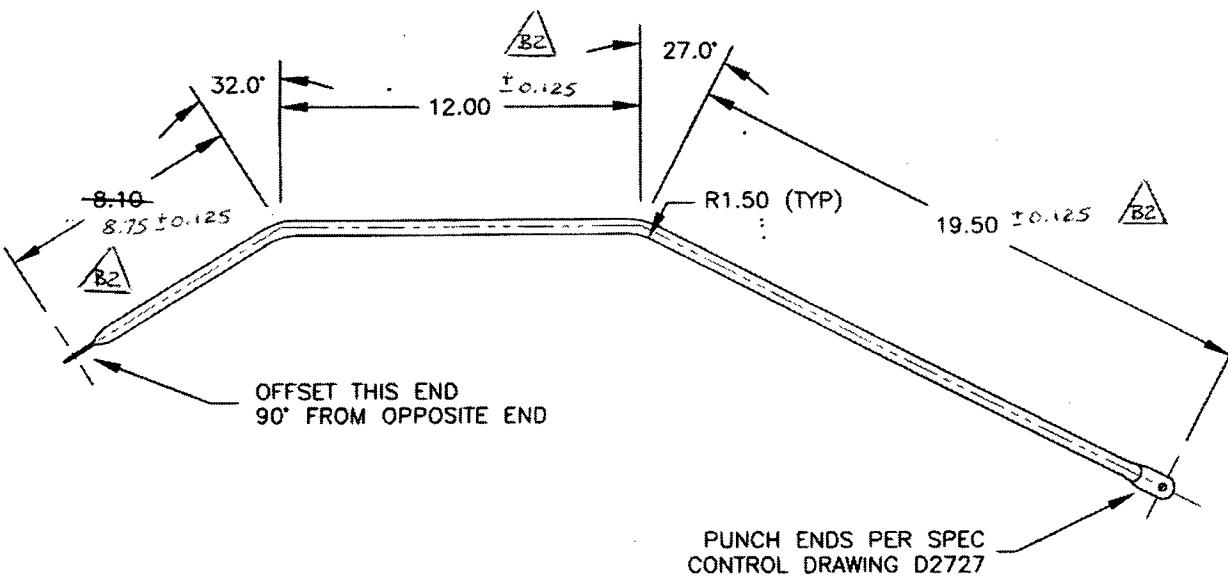
RELEASED

14/05/05 KG

DART

© COPY
DATE

DESIGN	DRAWN BY	DART AEROSPACE LTD	
KE	KE	HAWKESBURY, ONTARIO, CANADA	SHEET 1 OF 1
CHECKED	APPROVED	DRAWING NO.	REV. B
MM	JG	D2012-103	
DATE	TITLE	SCALE	
98.04.28	ARM	1:6	
A	92.06.08	NEW ISSUE	
B	98.04.28	CHANGE ANGLES (TSR A362)	
B1	02.05.25	ADDED FINISH	
B2	05.04.27	ADDED TOLERANCE : 8.75 MM; 8.10	



NOTES:

1. MAKE PER TEMPLATE DT8068 (WAS DT2012-103)
2. MATERIAL: AISI 304/316 STAINLESS STEEL TUBE Ø0.500 x 0.035 WALL
3. FINISH: POWDER COAT BLACK SANITEK (4.3S.7) PER DART QST 4.3 (B1)